

Date: Tuesday, 24/06/2008 1:19:43 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : D-PAD FACE
Job Number : 40035
Estimate Number : 13389
P.O. Number :
This Issue : 24/06/2008 S.O. No. :
Prsht Rev. : NC Part Number : PB6743001189
First Issue : / / Type : SMALL /MED FAB Drawing Number : B67-43001 P.25
Previous Run : Project Number : N/A
Material : B1
Due Date : 01/07/2008 Qty: 30 Um: Each
Written By :
Checked & Approved By : MF 08-06-24
Comment : est rev A new issue 08.06.19 EC verified: DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

~~M6061T6C063~~ D2914 142 *~~6061-T6 063 Sheet~~

3" Outer Tube *



Comment: Qty.: 0.0420 sf(s)/Unit Total : 1.2600 sf(s)

~~6061-T6 063 Sheet~~ 3" Outer Tube *batch: B11306* 08.06.2408.07.02 30

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Shear width as per dwg and roll

cut to length

08.06.24

1- cut to length (2.50") as per dwg

2- cut tube in half as per dwg

3- deburr

08.07.02 30

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.07.02

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA08.07.02 30

5.0

QC21

FINAL INSPECTION/W/O RELEASE





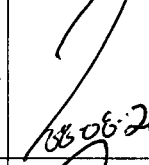


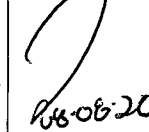
Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

Job Completion

08.08.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prd Mgr	Approval QC Inspector	
08.06.24	1.0	REPLACE M6061765063 W/ D2914 KZ		08/06/24		 08.06.24	 08.06.20	
08.06.24	2.0	CHANGE MANUFACTURING PROCEDURE AS OUTLINED (PTO).		08/06/24		 08.06.24	 08.06.20	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

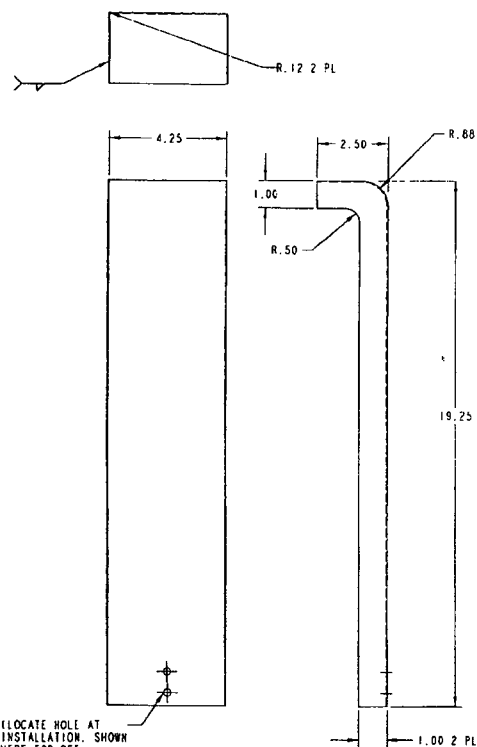
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

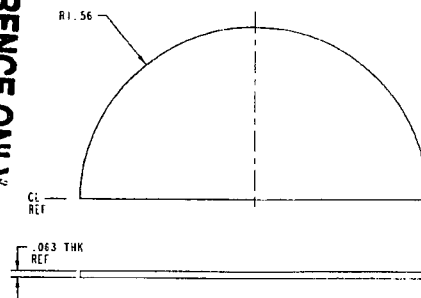
NOTE: Date & initial all entries

RELEASED

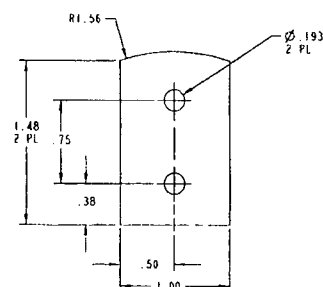
REFERENCE ONLY



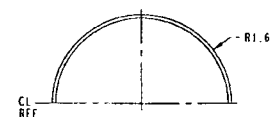
② -69 90 DEGREE COVER PLATE
MATERIAL: .032 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



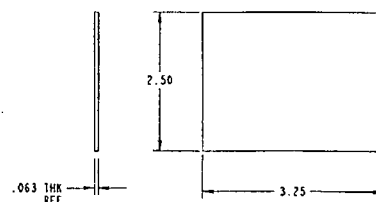
⑧ -339 D-PAD TOP
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



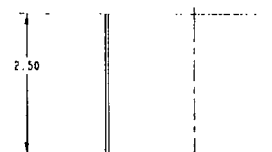
⑧ -193 D-PAD BASE
MATERIAL: .125 THK, 6061-T6, QQ-A-250/11
SCALE 2.000



⑥ -189 D-PAD FACE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000



⑥ -185 D-PAD BACK PLATE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000



40035

PREMIER AVIATION, INC.
2900 Aviation Parkway, Grand Prairie, Texas 75002
DATE: 01/08/88 BY: 81
DISC: 8 B67-43001
SCALE: 1/4" = 1"

ORIGINAL

[illegible]

SPLIT

DART AEROSPACE LTD		Work Order:	23986 A
Description: Clevis		Part Number:	B67-43001-89
Dwg: B67-43001 Rev. B page 30		Qty:	20
		Page 1 of 1	

Just This Batch only?
 05.09.08

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	0509-08	20
2	ML	Turn as per Dwg B67-43001 Material: 6061-T6 Bar, Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) " " " " " " Identify for B67-43001-89 <i>Issue P.O. Batch: 2008449</i>	U	0508-09	20
3	QC2 RG	Inspect parts as they come off the machine Identify as B67-43001-89 <i>Receive & inspect</i>	CJ	05/09/08	20
4	MM	Mill as per Dwg B67-43001 <i>N/A</i>			
5	QC2	Inspect parts as they come off the machine <i>N/A</i>			
6	QC6	Second check <i>Inspect Level 6</i>		05-09-08	20
7	MM	Deburr <i>if applicable</i>		05-09-08	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1		050916	20
9	FP	Powder Coat Green Sandtex (Ref. 43.5.8) as per QSI 005 4.3 Mask Ø0.860"			
10	QC3	Inspect Powder Coat		05.10.06	20
11	ST	Identify and Stock	CJ	05/10/06	5
12	AC	Cost / part: <i>18.16</i>	SAC	05.10-09	5
13	DC	Close W/O <i>18.16</i> Inspect Level 21		05/10/07	5

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	

RELEASED
 17/15/08 300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPLIT

DART AEROSPACE LTD		Work Order:	23986 B
Description: Clevis		Part Number:	B67-43001-89
Dwg: B67-43001 Rev. B page 30		Qty:	20
		Page 1 of 1	

Part 1 The Batch only
 05.09.08

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05.09.08	20
2	ML	Turn as per Dwg B67-43001 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) Identify for B67-43001-89 <i>Issue to Batch: 2008449</i>	U	05.08.09	20
3	QC2 K6	Inspect parts as they come off the machine Identify as B67-43001-89 <i>Receive & Inspect</i>	CL	05.09.08	20
4	MM	Mill as per Dwg B67-43001 <i>N/A</i>			
5	QC2	Inspect parts as they come off the machine <i>N/A</i>			
6	QC6	Second check <i>Inspect Level 6</i>		05.09.08	20
7	MM	Deburr <i>if applicable</i>		05.09.08	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	U	05.09.16	20
9	FP	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 <i>Mask 20.860"</i>			
10	QC3	Inspect Powder Coat	U	05.10.06	20
11	ST	Identify and Stock	CL	05.10.06	15
12	AC	Cost / part: <i>18.16</i>	54C	05.10.07	15
13	DC	Close W/O <i>18.16</i> Inspect Level 21	U	05.10.07	15

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature]
 11/15/08